

Work Order ID 84364

May-10-12 2:33:53 PM

84364

Page 1

Item ID: D4463-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tank Top Assembly

Start Date: 10/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/10 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4463

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/2/12/24

(24)

4

0

Jm

12-5-23

9

0

Jm

12-5-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84364

84364

Page 2

May-10-12 2:33:53 PM

Item ID: D4463-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Top Assembly
 Start Date: 10/05/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 24/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Small Fab	Memo	0.00				4X			
Small Fab	C'SINK HOLES AS PER DWG								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				4			
Hand Finishing									

[Handwritten signature]

[Handwritten mark]

7/6/12 5-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 84364

84364

Page 3

May-10-12 2:33:53 PM

Item ID: D4463-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Top Assembly
 Start Date: 10/05/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 24/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				4x			12/08/23
170 *170* Small Fab Small Fab	Memo INSTALL ANCHOR NUTS AS PER DWG	0.00 0.00				4x			12/08/23
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			12/08/24

SMB
12 824
DAS
16
12/08/24

PTO →

W/O: 84364

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4463-041 PAR #: _____ Fault Category: Sm Tab NCR: Yes ☒ No ☐ DQA: Aut Date: 12/09/18
 Resolution: _____ Disposition: Rework QA: N/C Closed: CK Date: 12/9/18

NCR: 12-1807

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/23	#100	Found at inspection of parts + not plates that the Alodine was too pale (not enough) P.C. not ^{scrubbed} brushed up enough	DAS 16 9-83 057047 12/08/23	Scrub with Scotch Brite (used DAS) Re Alodine Do Not Put in Acid	7/6 12-8-23	(DAS 16 9-83 12/08/23	(DAS 16 9-83 057042 12/08/23	(DAS 16 9-83 12/08/23
		before Alodine + missed at inspection LCA → RC MISSED PROCESS	DAS 16 9-83 057042 12/08/23				(DAS 16 9-83 057042 12/08/23	(DAS 16 9-83 12/08/23

NOTE: Date & initial all entries

Work Order ID 84364

May-10-12 2:33:53 PM

84364

Page 4

Item ID: D4463-041
 Revision ID:
 Item Name: Tank Top Assembly
 Start Date: 10/05/2012 Start Qty: 4.00
 Required Date: 24/05/2012 Req'd Qty: 4.00
 Reference:

Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <i>WMA</i> Memo	0.00 0.00				4	<i>d</i>		<i>12-08-12</i>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/9/13</i>

12-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-10-12 2:33:57 PM

Page 1

Work Order ID: 84364

84364

Parent Item: D4463-041

D4463-041

Parent Item Name: Tank Top Assembly

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC
12.04.25 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

365.8922

3.864

15.456

M6061T6S 063

6061-T6 .063 Sheet

**

Location

Loc Qty

Loc Code

MAT021

121805

365.8922000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

18.94

120218

19.5

120866

66.9426316

121578

142.75

121805

JM

12-5-23

MS20426AD3-4

Purchased

No

170

Each

3,240.000

48

192

MS20426AD3-4

RIVET

**

Location

Loc Qty

Loc Code

ST316

3240

104374

574

110398

2666

M121011

19200

NAS1473R3

Purchased

No

170

Each

136.0000

24

96

NAS1473R3

Anchor Nut

**

Location

Loc Qty

Loc Code

GA

36

121287

36

ST278

100

121615

100

M122141

9000

M121827

600

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84364
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099	✓		✓	HB-02
Ø0.206	+0.005/-0.001	0.206	✓		✓	HB-02
Ø1.00	+0.012/-0.001	1.00	✓		✓	HB-02
1.15	+/-0.030	1.162	✓		✓	HB-02
1.85	+/-0.030	1.863	✓		✓	HB-02
2.20	+/-0.030	2.204	✓		✓	HB-02
2.30	+/-0.030	2.315	✓		✓	HB-02
5.29	+/-0.030	5.298	✓		U	HB-02
8.30	+/-0.030	8.315	✓		✓	HB-02 Prod w/ 302
8.93	+/-0.030	8.941	✓		✓	HB-02 Prod w/ 302
8.98	+/-0.030	8.993	✓		✓	HB-02 Prod w/ 302
9.31	+/-0.030	9.313	✓		✓	Prod w/ 302
10.42	+/-0.030	10.424	✓		U	Prod w/ 302
11.26	+/-0.030	11.270	✓		✓	Prod w/ 302
1.61	+/-0.030	1.616	✓		✓	HB-02
1.68	+/-0.030	1.683	✓		✓	HB-02
1.82	+/-0.030	1.827	✓		✓	HB-02
3.41	+/-0.030	3.420	✓		✓	HB-02
3.79	+/-0.030	3.801	✓		✓	HB-02
6.43	+/-0.030	6.433	✓		✓	HB-02
7.36	+/-0.030	7.369	✓		✓	HB-02
7.80	+/-0.030	7.808	✓		✓	HB-02
10.75	+/-0.030	10.751	✓		✓	HB-02 Prod w/ 302
11.38	+/-0.030	11.388	✓		✓	Prod w/ 302
11.80	+/-0.030	11.810	✓		✓	HB-02 Prod w/ 302
13.27	+/-0.030	13.27	✓		MT	HB-01
1.15	+/-0.030	1.161	✓		✓	HB-02
3.00	+/-0.030	3.014	✓		✓	HB-02
3.26	+/-0.030	3.266	✓		✓	HB-02
7.00	+/-0.030	7.010	✓		✓	HB-02
10.74	+/-0.030	10.760	✓		✓	Prod w/ 302
11.00	+/-0.030	11.008	✓		✓	Prod w/ 302
11.63	+/-0.030	11.650	✓		✓	HB-02 Prod w/ 302
15.29	+/-0.030	15.29	✓		MT	HB-01
15.48	+/-0.030	15.48	✓		MT	HB-01
19.48	+/-0.030	19.48	✓		MT	HB-01
23.48	+/-0.030	23.48	✓		MT	HB-01
23.67	+/-0.030	23.67	✓		MT	HB-01
24.11	+/-0.030	24.11	✓		MT	HB-01
27.46	+/-0.030	27.46	✓		MT	HB-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84364
Description: Tank Top		Part Number: D4463-1
Inspection Dwg: D4463	Rev: C	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
28.08	+/-0.030	28.08	✓		MT	H1B-01
30.05	+/-0.030	30.05	✓		MT	H1B-01
33.35	+/-0.030	33.35	✓		MT	H1B-01
33.40	+/-0.030	33.40	✓		MT	H1B-01
35.33	+/-0.030	35.33	✓		MT	H1B-01
2.38	+/-0.030	2.384	✓		V	H1B-02
3.82	+/-0.030	3.833	✓		V	H1B-02
7.53	+/-0.030	7.549	✓		V	H1B-02
11.14	+/-0.030	11.143	✓		V	Prod. w/ J-02
14.86	+/-0.030	14.86	✓		MT	H1B-01
15.76	+/-0.030	15.76	✓		MT	H1B-01
20.01	+/-0.030	20.01	✓		MT	H1B-01
23.95	+/-0.030	23.95	✓		MT	H1B-01
27.55	+/-0.030	27.55	✓		MT	H1B-01
31.06	+/-0.030	31.06	✓		MT	H1B-01
33.08	+/-0.030	33.08	✓		MT	H1B-01
33.71	+/-0.030	33.71	✓		MT	H1B-01
0.063	+/-0.010	0.061	✓		V	H1B-02

Measured by: JM	Audited by: S	Preliminary Approval:
Date: 12-5-23	Date: 12/5/23	Date:

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue P/O D4463-041	KJ	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

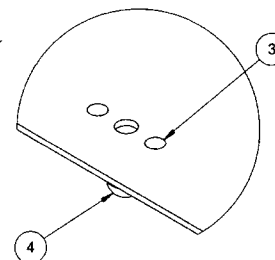
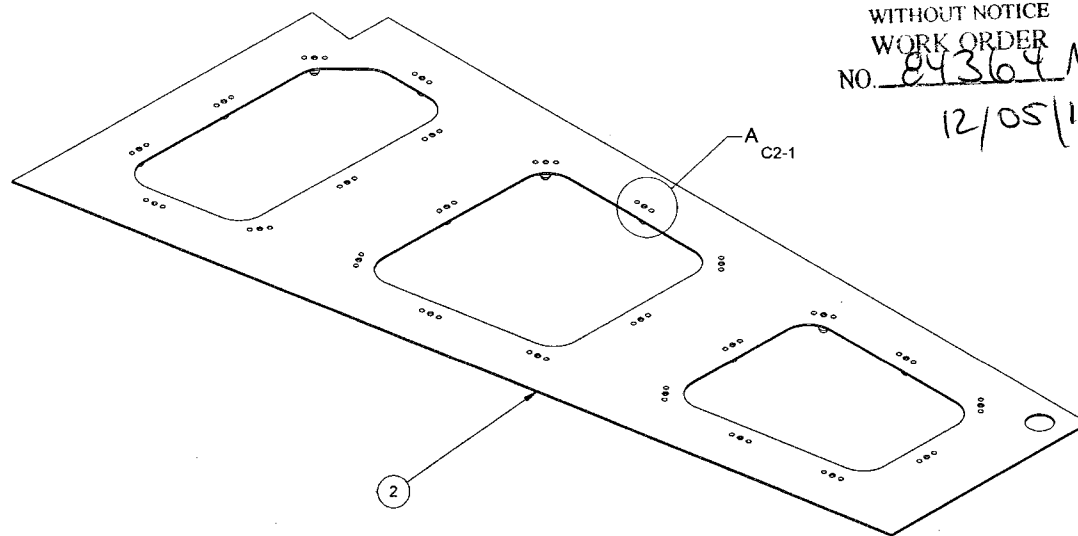
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4463-041	TANK TOP ASSEMBLY
2	1	D4463-1	TANK TOP
3	48	MS20426AD3-4	RIVET
4	24	NAS1473R3	ANCHOR NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84364 MLJ
12/05/10



DETAIL A
C4-1

D4463-041 TANK TOP ASSEMBLY

RELEASE
2012-04-24

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.76 lbs

C	ADD DIMS: ZN B5-5, D5-5, B2-11, B7-11, D3-11. ADD -13, MODIFY -1/-11.	DC	12.03.23
B	ADD D4463-041, ZN C5-1. UPDATED -1/-3/-5/-7/-9, COMBINED -11 & -13 INTO -11.	DC	11.12.14
A	NEW ISSUE	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4463 REV. C SHEET 1 OF 14 TITLE TANK SCALE NTS DATE 12.03.23 <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>		
MFG. APPR.	<i>BC</i>		
APPROVED	<i>BC</i>		
DE APPR.	<i>BC</i>		

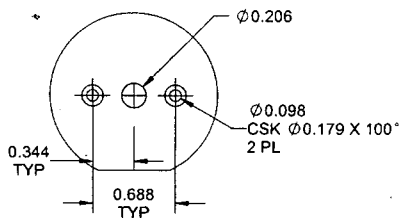
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

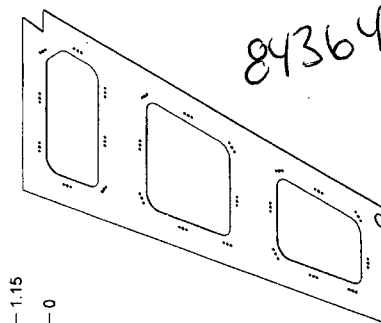
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

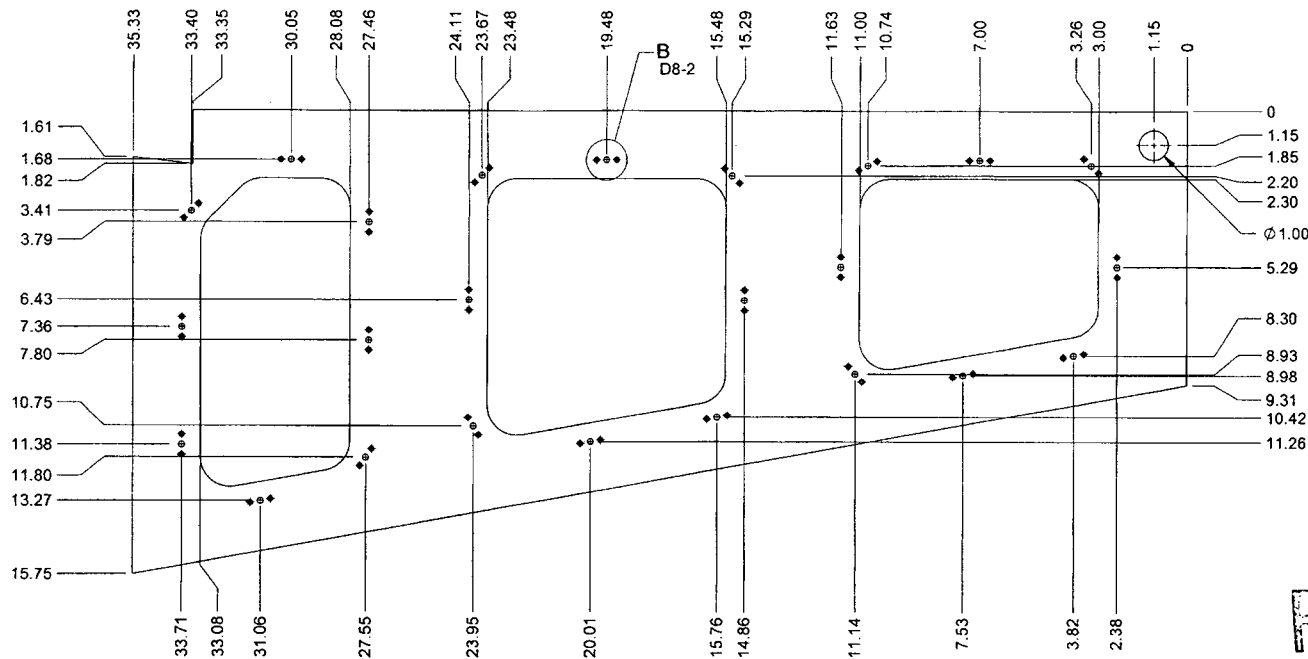
NOTE: Date & initial all entries



DETAIL B
(24 PL)
C5-2



0.063
REF



D4463-1 TANK TOP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.70 lbs

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DC	D4463	SHEET 2 OF 14
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	TANK	NTS
DATE	12.03.23	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2012-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

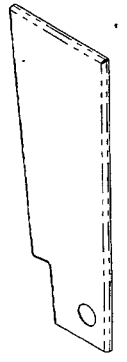
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

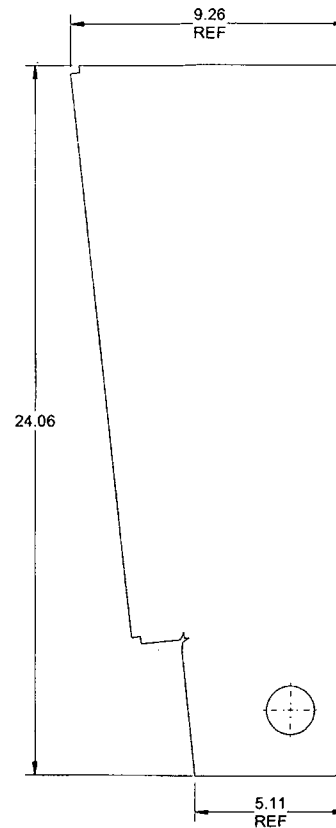
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24364



0.50
TYP
R0.19
TYP



D4463-3 TANK AFT END

RELEASE
2012-04-24

- NOTES:
- 1) MATERIAL: MADE FROM D4463-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.24 lbs

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	EE	D4463	SHEET 3 OF 14
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	TANK	NTS
DATE	12.03.23	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

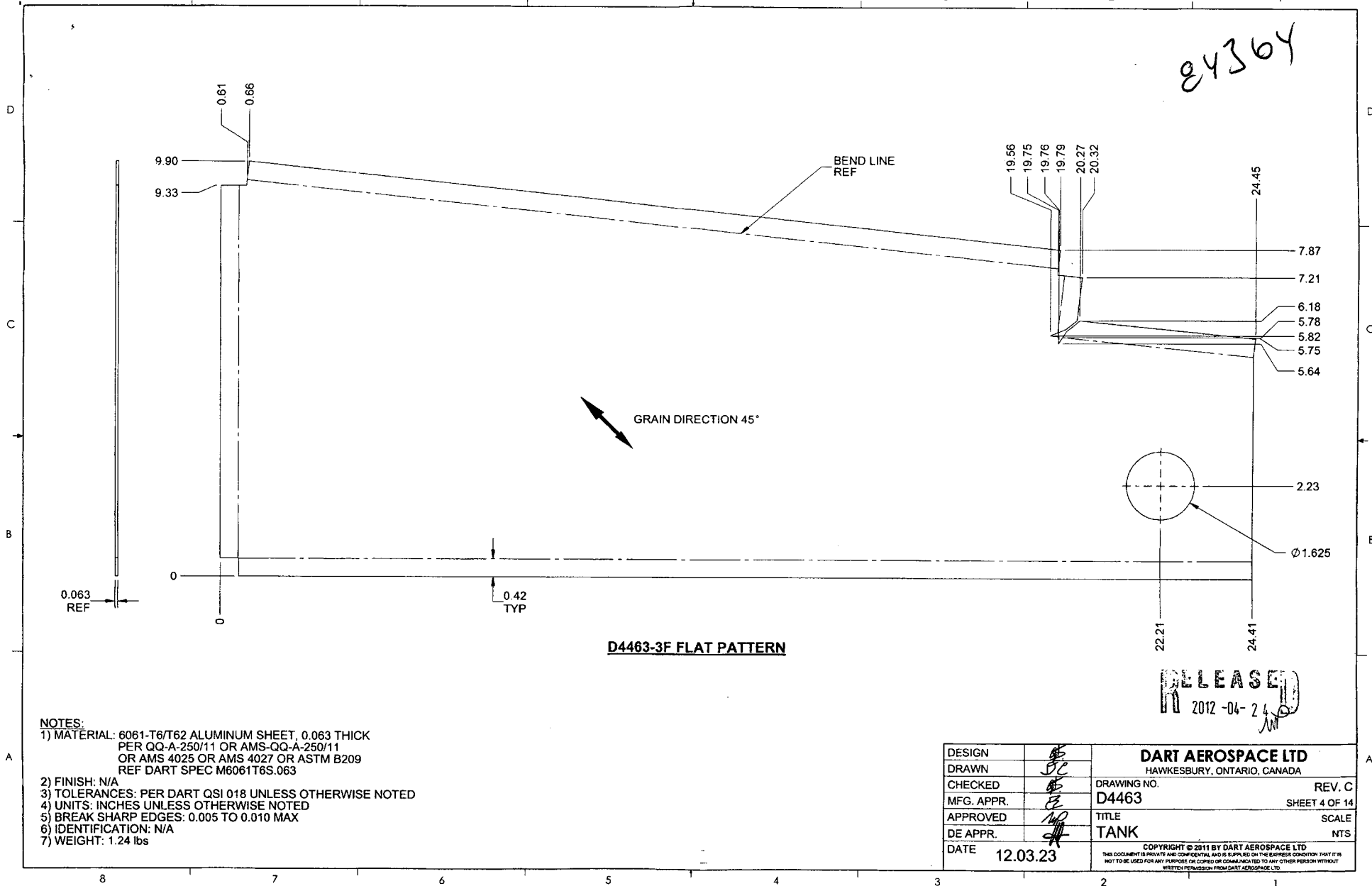
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24364



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.24 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4463	SHEET 4 OF 14
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

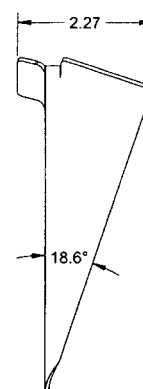
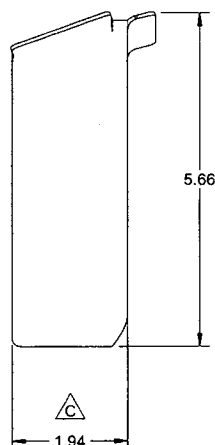
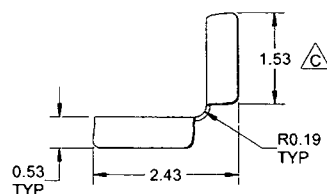
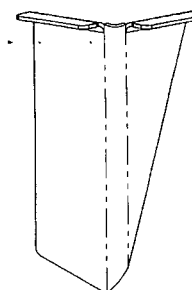
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84364



D4463-5 TANK UPPER CUT OUT

RELEASED
2012-04-24
MP

- NOTES:
- 1) MATERIAL: MADE FROM D4463-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4463	SHEET 5 OF 14
APPROVED	MP	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

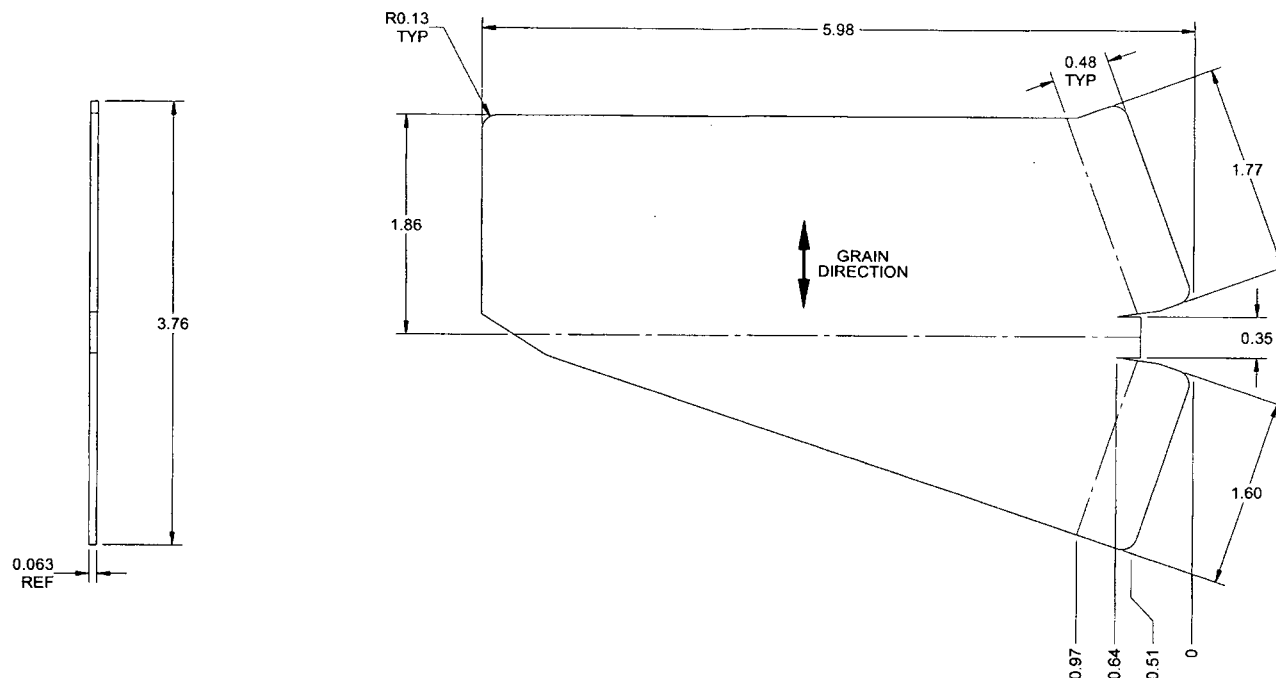
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84364



D4463-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) PROFILE PER DWG FILE "D4463-5F-REV C.DXF"

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. C
MFG. APPR.	CE	D4463	SHEET 6 OF 14
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	TANK	NTS
DATE	12.03.23	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

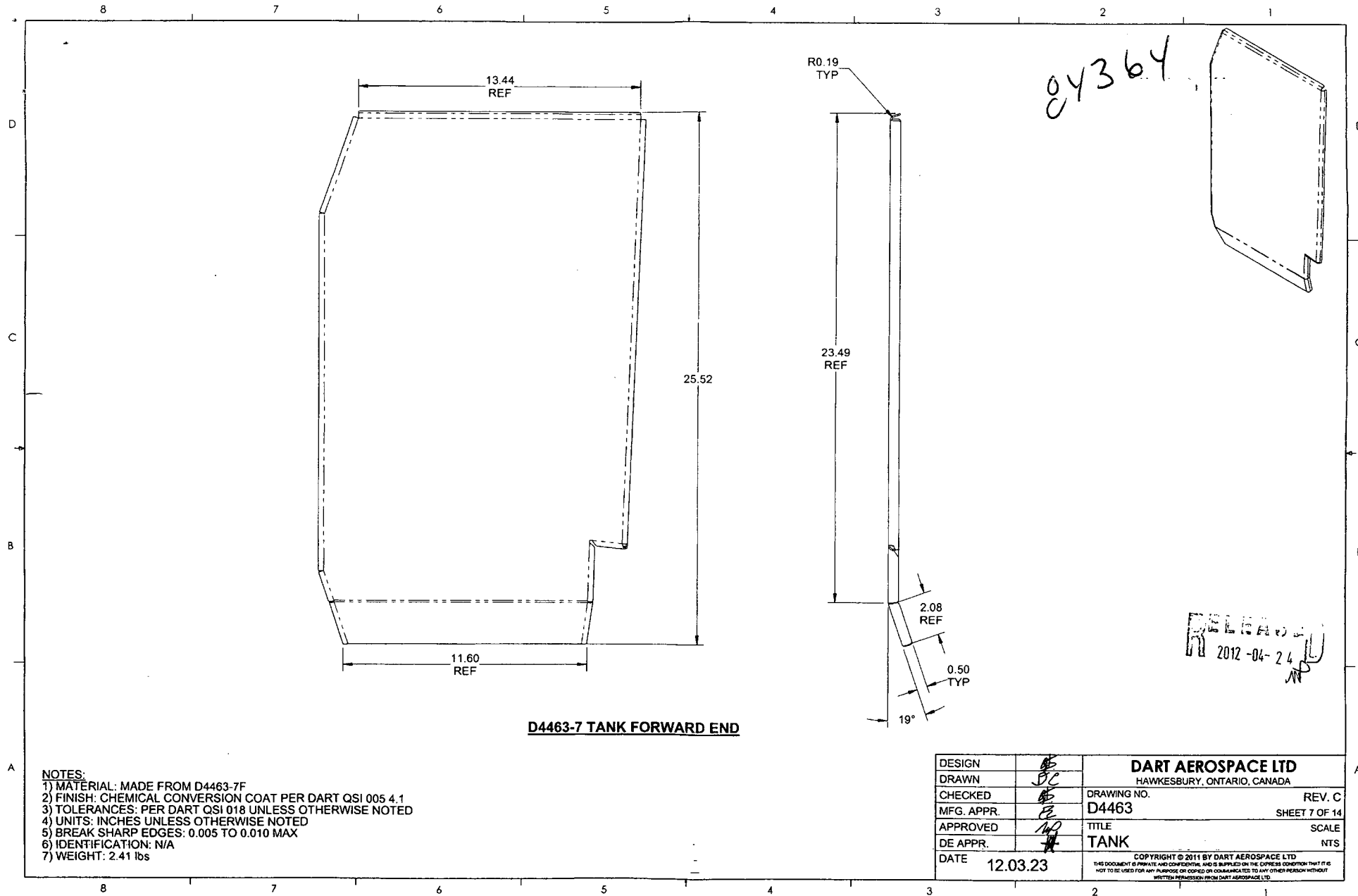
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: MADE FROM D4463-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.41 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D4463	SHEET 7 OF 14
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

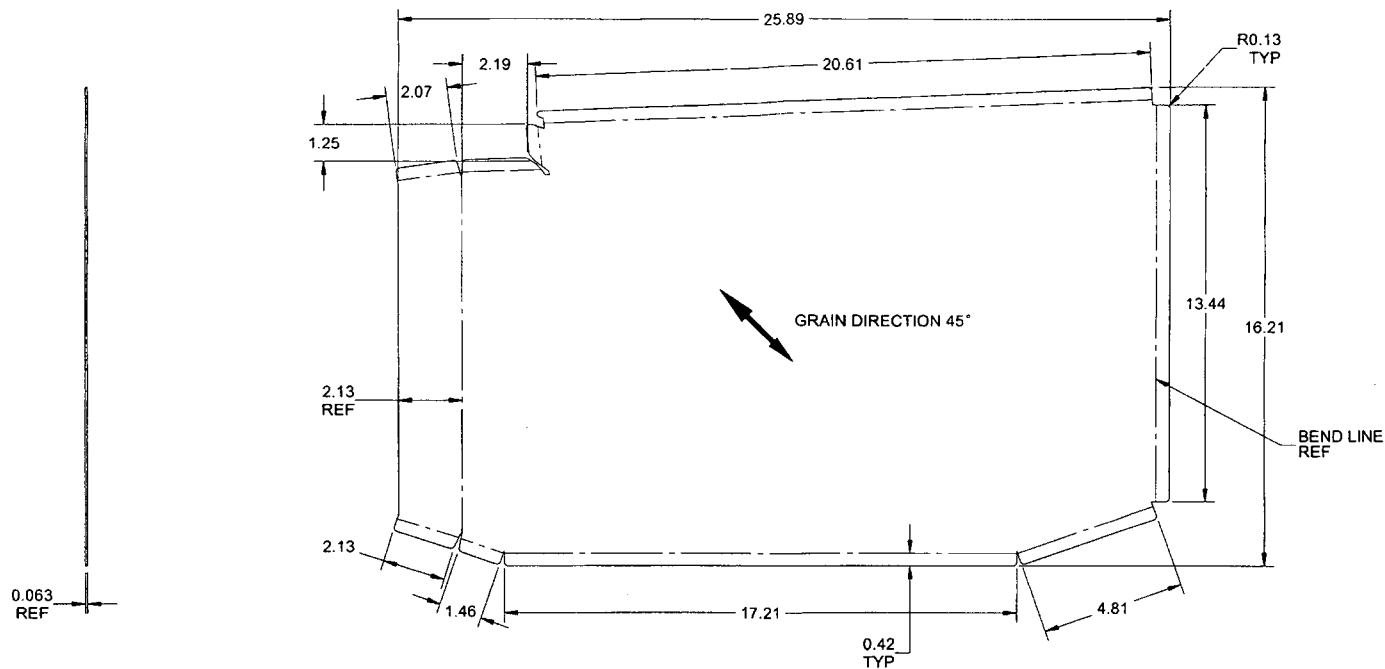
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24364



D4463-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.41 lbs
- 8) PROFILE PER DWG FILE "D4463-7F-REV C.DXF"

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4463	SHEET 8 OF 14
APPROVED	JS	TITLE	SCALE
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

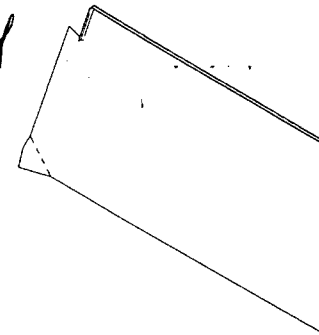
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

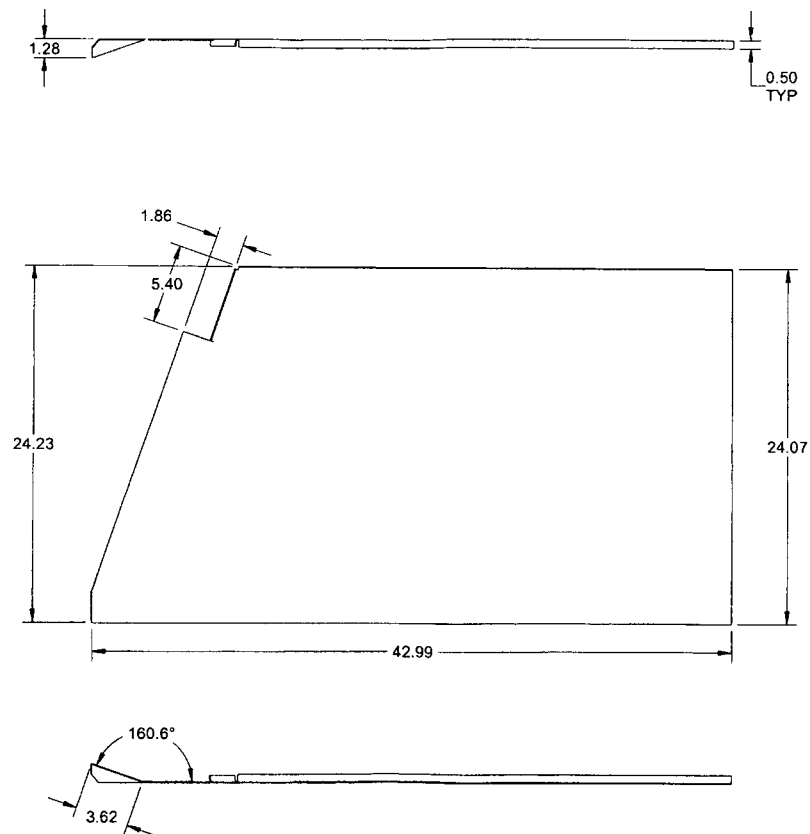
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84364



R0.19
REF



D4463-9 TANK BACK

NOTES:

- 1) MATERIAL: MADE FROM D4463-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.90 lbs

RELEASED
2012-04-24

DESIGN		DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	CE	D4463	SHEET 9 OF 14
APPROVED	NO	TITLE	SCALE
DE APPR.		TANK	NTS
DATE	12.03.23	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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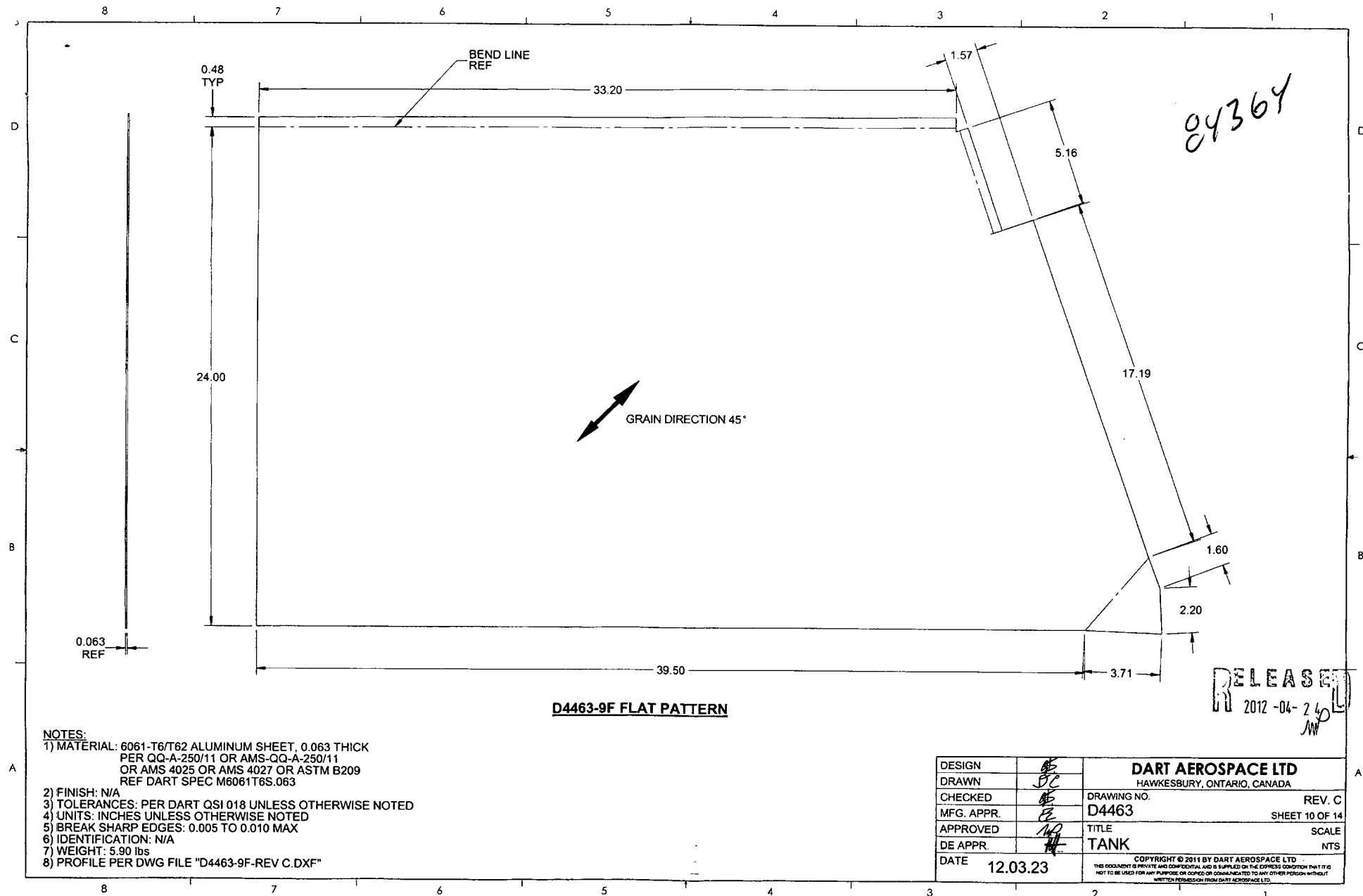
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

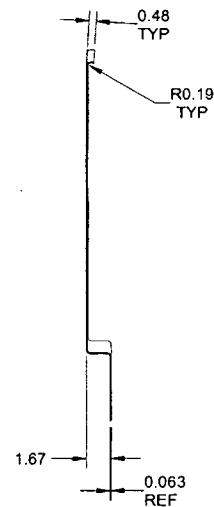
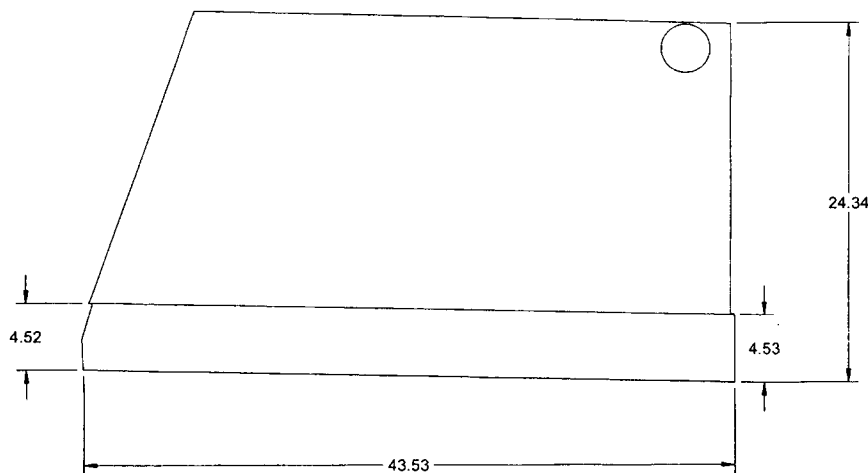
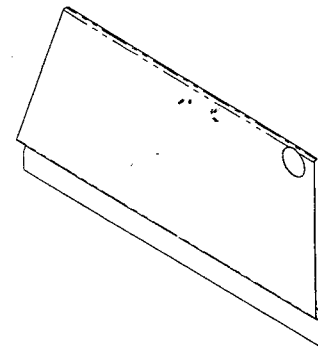
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24364



RELEASED
2012-04-24

D4463-11 TANK FRONT

- NOTES:**
- 1) MATERIAL: MADE FROM D4463-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.40 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	BE	D4463	SHEET 11 OF 14
APPROVED	140	TITLE	SCALE
DE APPR.	#	TANK	NTS
DATE	12.03.23	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Figure 1 is a technical drawing of a rectangular plate with a circular hole. The drawing includes the following dimensions and features:

- Hole Dimensions:** The hole has a diameter of $\text{Ø } 3.25$. The distance from the top edge of the plate to the center of the hole is 26.08 . The distance from the bottom edge of the plate to the center of the hole is 24.06 . The distance from the left edge of the plate to the center of the hole is 3.27 . The distance from the right edge of the plate to the center of the hole is 0.26 .
- Plate Thickness:** The thickness of the plate is 0.41 TYP.
- Grain Direction:** The grain direction is indicated by a double-headed arrow pointing vertically, labeled "GRAIN DIRECTION".
- Bend Line Reference:** A line is drawn across the plate, labeled "BEND LINE REF".
- Other Dimensions:** The distance from the top edge of the plate to the bend line reference is 36.08 . The distance from the bottom edge of the plate to the bend line reference is 0.86 . The distance from the left edge of the plate to the bend line reference is 6.12 . The distance from the right edge of the plate to the bend line reference is 6.73 . The distance from the left edge of the plate to the bend line reference is 5.85 . The distance from the right edge of the plate to the bend line reference is 6.64 . The distance from the left edge of the plate to the bend line reference is 4.54 . The distance from the right edge of the plate to the bend line reference is 5.36 . The distance from the left edge of the plate to the bend line reference is 4.34 . The distance from the right edge of the plate to the bend line reference is 5.18 . The distance from the left edge of the plate to the bend line reference is 0 . The distance from the right edge of the plate to the bend line reference is 2.96 . The distance from the left edge of the plate to the bend line reference is 0.27 . The distance from the right edge of the plate to the bend line reference is 43.53 . The distance from the left edge of the plate to the bend line reference is 43.59 .

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.40 lbs



D4463-11F FLAT PATTERN

DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4463 TITLE TANK COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.</small>	REV. C
DRAWN			
CHECKED	<i>BC</i>		SHEET 12 OF 14
MFG. APPR.	<i>BC</i>		SCALE
APPROVED	<i>MA</i>		NTS
DE APPR.			
DATE	12.03.23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

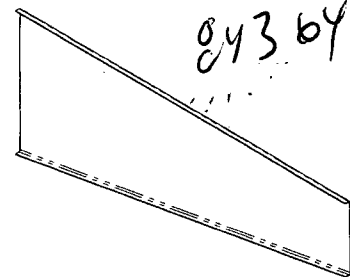
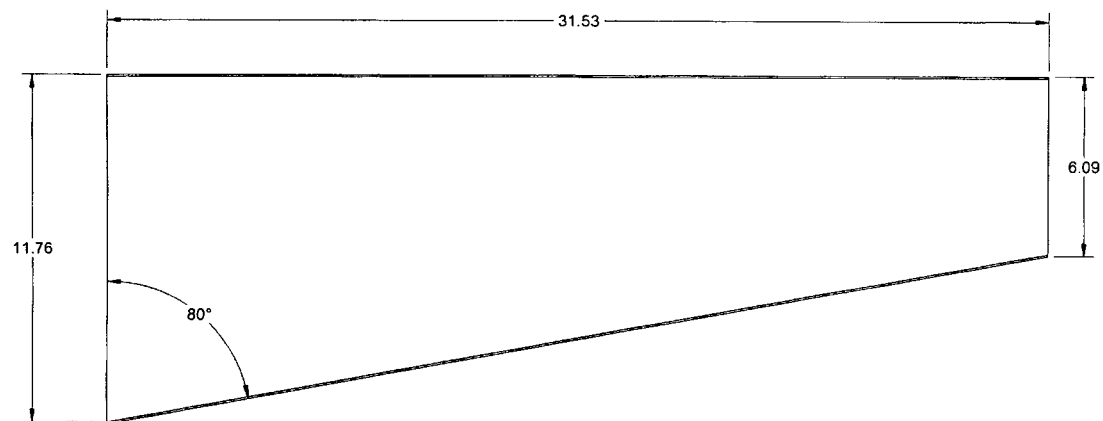
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

R0.19
TYP

0.50
TYP



D4463-13 TANK BOTTOM

RELEASED
2012-04-24

NOTES:

- 1) MATERIAL: MADE FROM D4463-13F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.88 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BC</i>	D4463	SHEET 13 OF 14
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

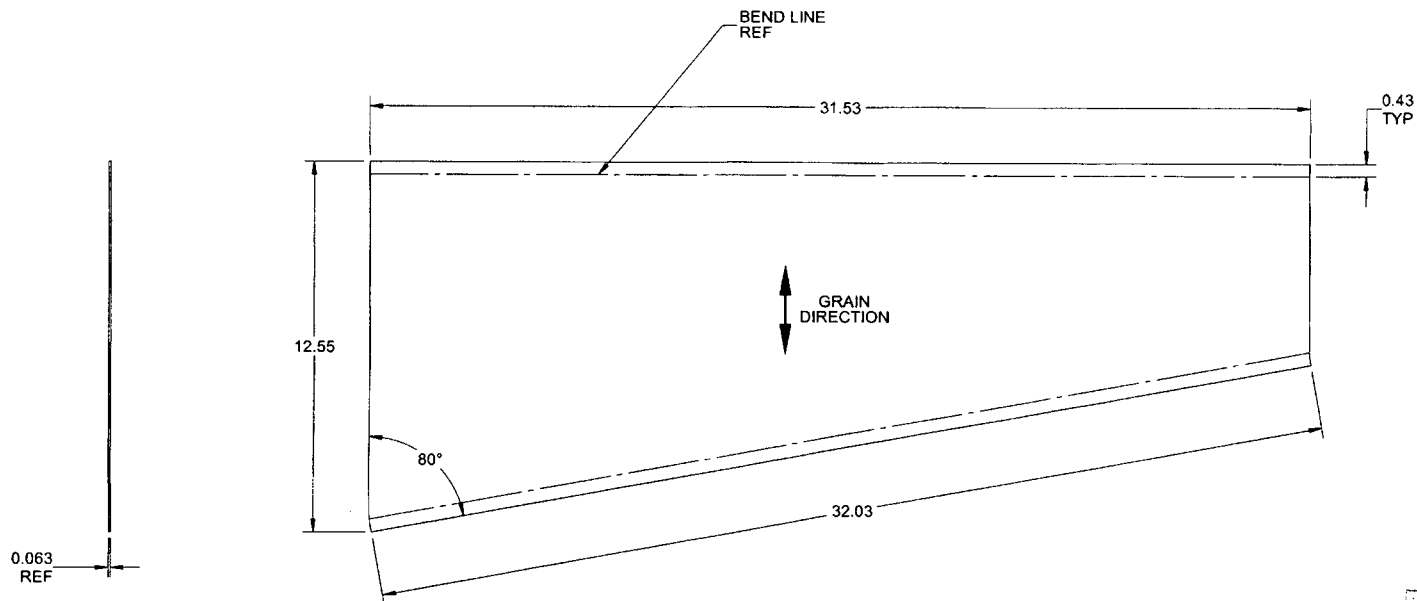
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24364



D4463-13F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M0061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.88 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4463	SHEET 14 OF 14
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries